Dart Aerospace Ltd. Wednesday, 2/1/2006 11:45:22 AM Kim Johnston **Process Sheet Drawing Name** : STOP : CU-DAR001 Dart Helicopters Services : 25715 b Number : 10515 stimate Number : D28053 Part Number : NIA O.Number D2805 REV. B S.O. No. : N/A **Drawing Number** : 2/1/2006 histissue : N/A **Project Number** Prsht Rev. NIA : B : MACHINED PARTS **Drawing Revision** First Issue Type :NIA : NIA Material **Previous Run** 12 Um: **Due Date** : 2/28/2006 Qty: Written By Checked & Approved By : Est: Comment **Additional Product** Job Number: Seq. #: **Machine Or Operation:** Description: 6061-T6 Bar 1.5" x 1.5" 1.0 M6061T6B1500X01500 3.3075 f(s) Total: Comment: Qty.: 0.2756 f(s)/Unit 6061-T6 Bar 1.5" x 1.5" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5" Batch: MI (M6061T6B1500X01500) 2.0 BAND SAW BAND SAW Comment: BAND SAW +0.010/-0.030" Cut Bar: 3.150" Long HAAS CNC VERTICAL MACHINING # 3.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA104 and Dwg D2805 2- Tumble and Deburr

06.02-12 (12)

Z 1

Page 1

4.0

5.0

Comment: INSPECT

QC8

Comment: SECOND CHECK

Identify as D2805-3

ARTS AS THEY COME OFF MACHINE

SECOND CHECK

Each

pt.a

## Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector	
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Part No: _	_ PAR #:	/‡ Fault Category:	NCR: Yes No DQA:	Date: 0/02/2
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC	Corrective Action Section B			Verification	Approval	Approval		
DAIL	OIL.	Section A	Initial Action Description   Sign & Date		Sign & Date	Section C	Chief Eng	QC Inspector		
0C/02/W	3	2 pieces oversized	1 4	Toolholder changed	17 = R		A			
		Holes	ALCO D			16/	OSEND			
		2 pieces toothin	OFINA	in the vice hopers	06/02/11	world	CALL	B601.14		
		chuck wore out.)		Destroy and replace		, DC-00				
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NOTE: Date & initial all entries

Wednesday, 2/1/2006 11:45:22 AM Daté: User: Kim Johnston **Process Sheet Drawing Name: STOP** Customer: CU-DAR001 Dart Helicopters Services Part Number: D28053 Job Number: 25715 Job Number: Description: Seq. #: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 do-12-15 \* Comment: INSPECT ALODINE PACKAGING RESOURCE #1 PACKAGING 1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock St 387 Location: 9.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

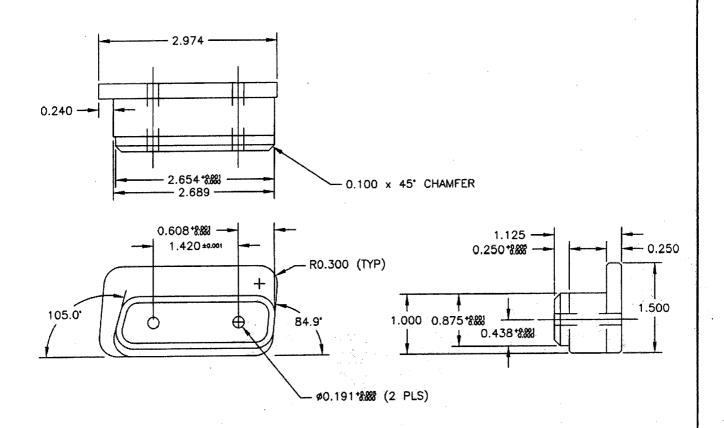
## **Dart Aerospace Ltd**

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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PR	OCEDURE CHAI	<b>IGE</b>	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·							
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA	·	Date:	
					QA: N	/C Closed:	·	_ Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
		Description of NC	.	Corrective Action Section	า B	Verifica	tion	Annroval	Approval Chief Eng  Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C			
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**OTE:** Date & initial all entries



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D2805-1 (SHOWN) D2805-2 (OPPOSITE)

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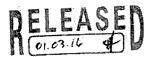
ENGINEERING BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOT TROLLED COPY BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED TO AMENDMENT MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) WITHOUT NOTICE FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

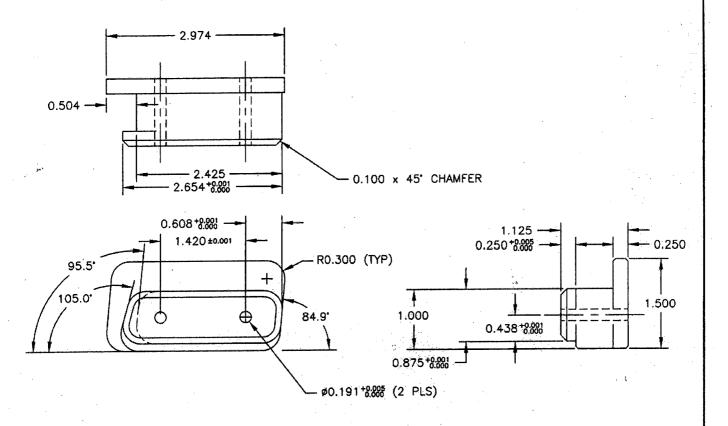
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<u>D2805-3 (SHOWN)</u> <u>D2805-4 (OPPOSITE)</u> SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COPY

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED AMENDMENT BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED WITHOUT NOTICE MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) WORK ORDER FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1

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Description:	DART AEROS	SPACE LTD				Work Order:		
FIRST ARTICLE INSPECTION CHECKLIST    First Article	Description:	1				Part Number:		<u> </u>
First Article	Inspection Dwg	: Rev:					Pa	ige 1 of 1
First Article		FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
Dimension   Tolerance   Dimension   Accept   Reject   Reject   Inspection   Comments			<del>-</del> -1		<del>-</del>			
0,504 0,503" 2,425 2,44 2,425 2,654 1,001 2,655 0,608 1,001 1,421 0,191 1,425 1,123 1,125 1,235 1,233 1,125 1,001 1,001 0,438 1,001 1,439 0 0,875 1,001 1,439 0 1,500 1,496"  Measured by: 5F. Audited by: 5A Prototype Approval:		Tolerance		Accept	Reject		Co	mments
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01250 ± 805 0,252 1,000 1,001 0,438 + 805 4,875 0,250 1,245" 1,500 1,496"  Measured by: 7F. Audited by: 5A Prototype Approval:	0,1910	+,005	193					
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